

Re print

Work Order ID 137998

Monday, October 19, 2015 1:45:09 PM

137998

PRELIMINARY

Page 1

Item ID: D4364-041

POSITIVE
REC.

Accept

N900040100

Setup 9-89 Start

NS1

Revision ID:

Item Name: Run-on Landing Wearplate Fwd

Stop *NS2*

Start Date: 10/19/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: OCT 19 2015

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4364	et Rev C
-------	----------

DAS
9
9-89

150		0.00
-----	--	------

150

Large Fab

Memo

0.01

Large Fab

***FRONT BENT COULD BE OVER BENT HIGHER ***

1- Weld D4365-041 to wearplate as per dwg D4364

304 S.S. Welding Rod

BATCH #: M123823

2- Transfer drill holes in bar

1 12/15/11-2

160	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

160

QC

Memo

0.00

Quality Control

15-11-10
DAS
9
9-89

Monday, October 19, 2015 1:45:09 PM

PRELIMINARY 1981

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/19/2015 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 10/19/2015 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

① 15-11-10

DAS
9
9-89

0.00

180

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 10 dwg D4364.

TESTURED COATING B#: 133152

1

DAS
41
9-89
15-11-17

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

+

DAS
38
9-89
NOV 18 2015

Work Order ID 137998

Monday, October 19, 2015 1:45:09 PM

137998

Page 3

Item ID: D4364-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Run-on Landing Wearplate Fwd
 Start Date: 10/19/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/19/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>PRELIM</u>	0.00							DAS 38 9-89
200									
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								
									(12) 12/07/10
210	QC21- Final Inspection - Work Order Release	0.00							NOV 18 2015
210									17/7/10
QC	Memo	0.00							
Quality Control									JUL 10 2017

POSITIVE RECALL

EFFECTIVE ML5 AUTH OCT 19 2015
 RELEASED DAS DATE 10/27
 9-89

Picklist Print

Monday, October 19, 2015 1:45:13 PM

Page 1

Work Order ID: 137998

137998

Parent Item: D4364-041

D4364-041

Parent Item Name: Run-on Landing Wearplate Fwd

Start Date: 10/19/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC
REV:B 14.04.22 DWG B DD VERF:JLM
15.10.16 AS PER DWG REV.C1 DD VERF:JLM

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4364-1		Manufactured	No				Each	11.0000		1			
---------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

D4364-1

Plate

Q 15-11-3

Location

Loc Qty

Loc Code

WA001

7

123514

1

136706

6

WA002

4

135612

4

D4365-041

Manufactured No

Each

0.0000

1

D4365-041

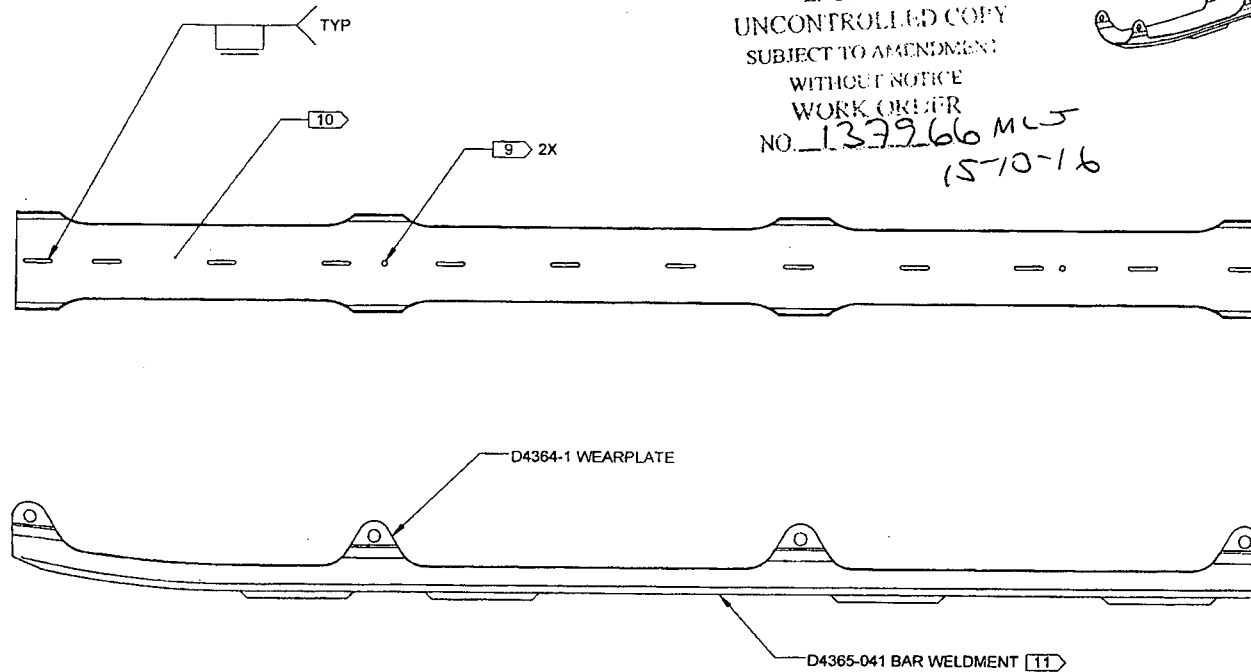
Bar Weldment

Q 15-11-3

137975+1

ITEM	QTY	P/N	DESCRIPTION
	X	D4364-041	WEARPLATE ASSY
1	1	D4364-1	PLATE
2	1	D4365-041	BAR WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137966 MJS
15-10-16



D4364-041 FWD WEARPLATE ASSY

NOTES:

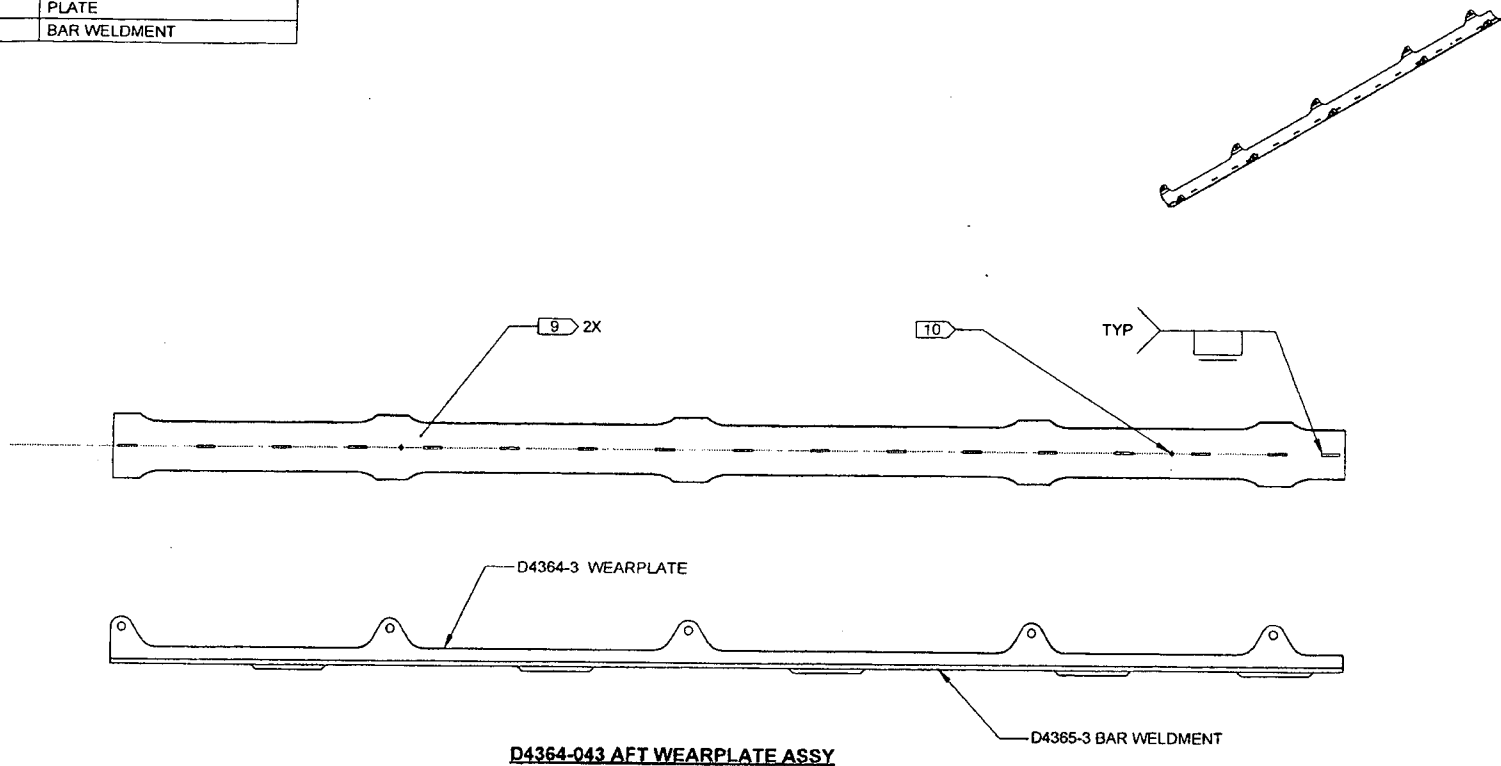
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-041" PER QSI 044 6.1
- 7) WEIGHT: D4364-041 = 4.95 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4365-041 BAR TO D4364-1 WEARPLATE AFTER WELDING
- 11) FORM TO MATCH PROFILE OF D4364-1 AT TIME OF WELDING

PRELIMINARY ISSUE

C	D4365-041 WAS D4365-1, D4365-043 WAS D4365-3, REMOVE 2059B HARDCOAT WELD	DB	15.09.18
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), CHANGE NOTE 19 (SH 2)	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	AJS	DRAWING NO.	REV. 8
MFG. APPR.	DD	D4364	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	15.09.18	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ELIMINATED

ITEM	QTY	P/N	DESCRIPTION
	X	D4364-043	WEARPLATE ASSY
1	1	D4364-3	PLATE
2	1	D4365-043	BAR WELDMENT



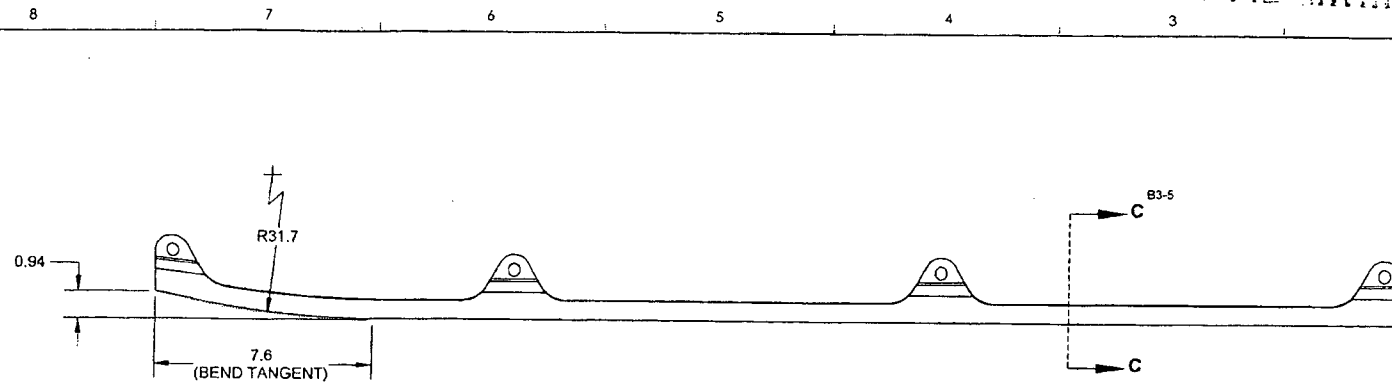
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-043" PER QSI 044 6.1
- 7) WEIGHT: D4364-043 = 7.03 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4365-043 BAR TO D4364-3 WEARPLATE AFTER WELDING

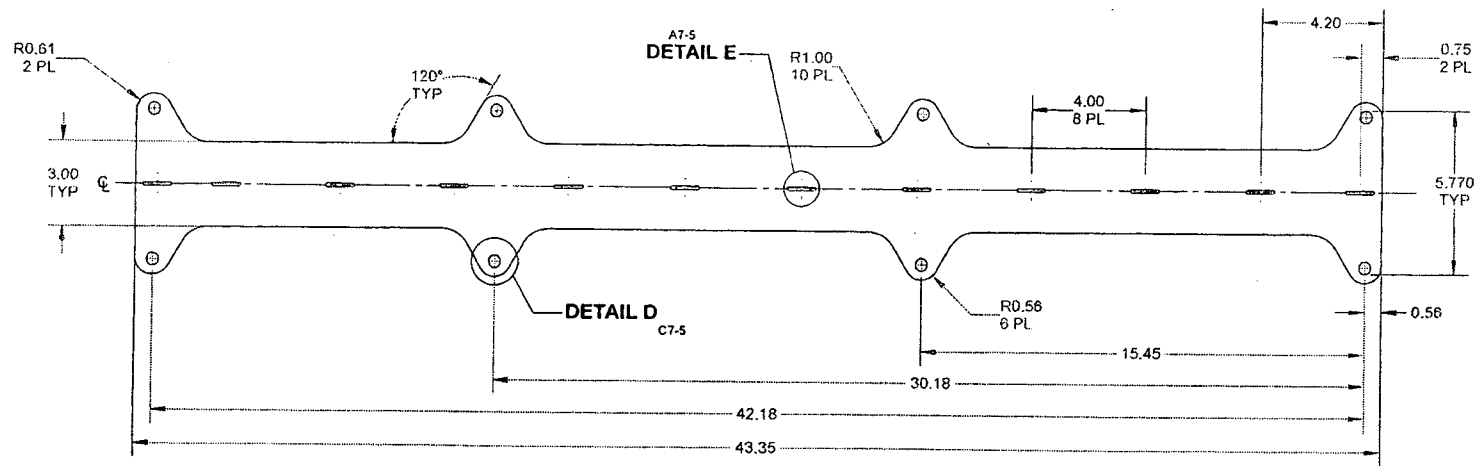
PRELIMINARY ISSUE

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. &
MFG. APPR.	DD	D4364	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	15.09.18	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

PRELIMINARY ISSUE



D4364-1 PLATE
(MAKE FROM D4364-1F)



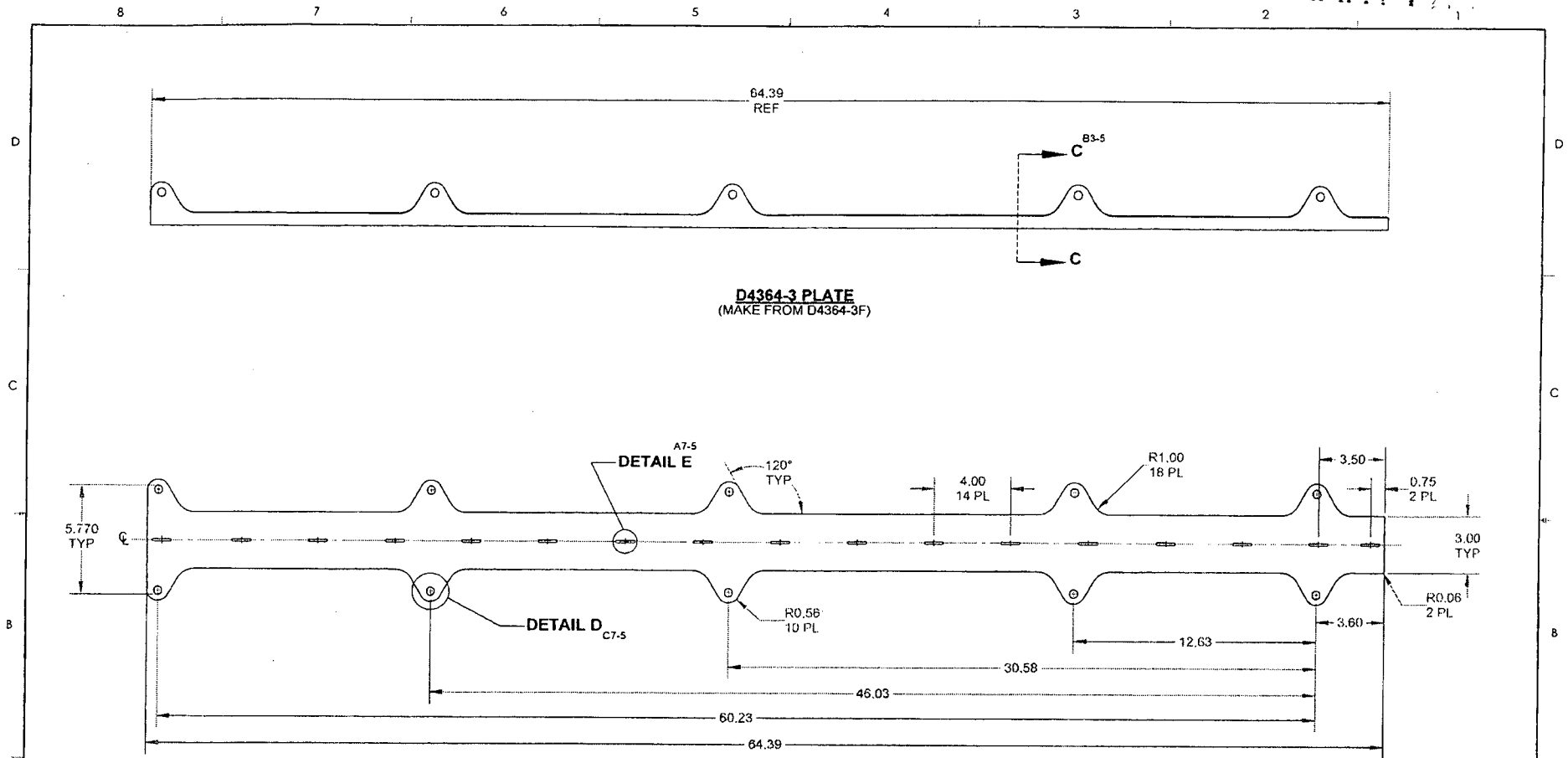
D4364-1F PLATE
(FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

PRELIMINARY ISSUE

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. 0
MFG. APPR.	DD	D4364	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	15.09.18	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SECRET
 DART AEROSPACE USA, INC.
 15.09.18

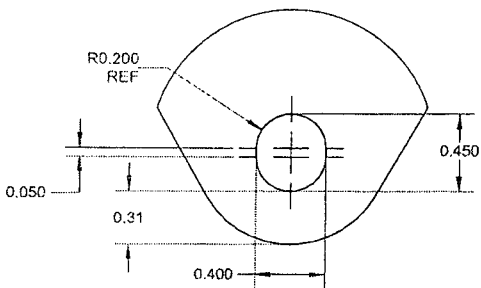


NOTES:

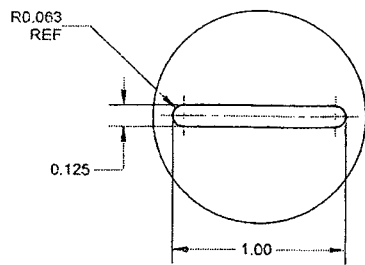
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.10 lbs

PRELIMINARY ISSUE

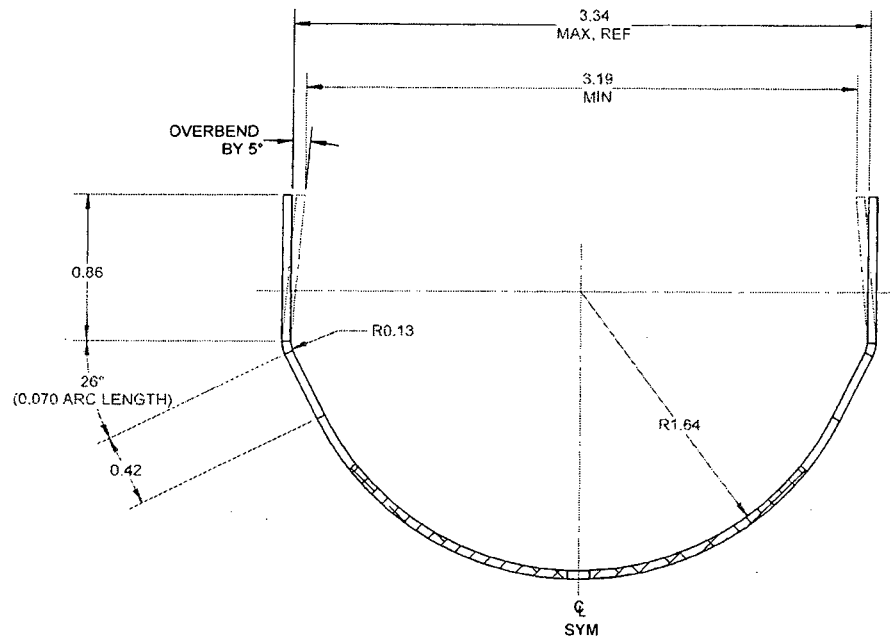
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. & C1
MFG. APPR.	DD	D4364	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	15.09.18	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



DETAIL D
SLOT DETAIL TYP
B5-3
B5-4



DETAIL E
SLOT DETAIL TYP
C5-3
C5-4



SECTION C-C

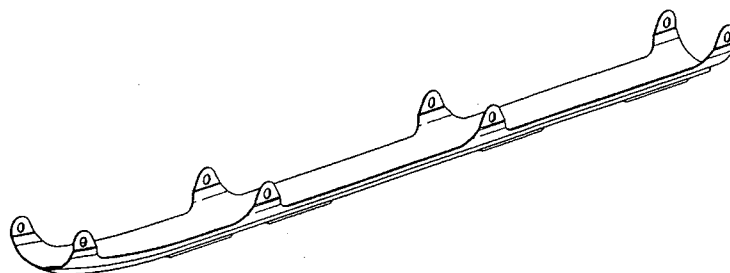
D3-3
D3-4

PRELIMINARY ISSUE

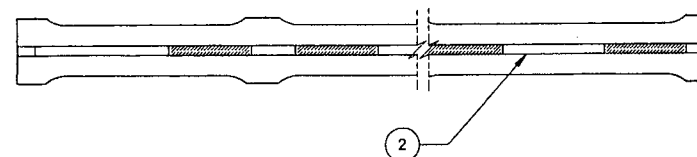
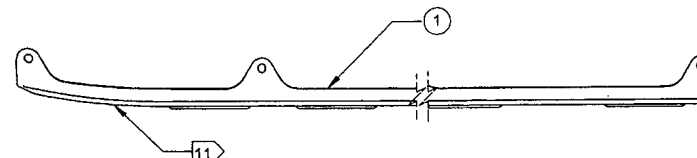
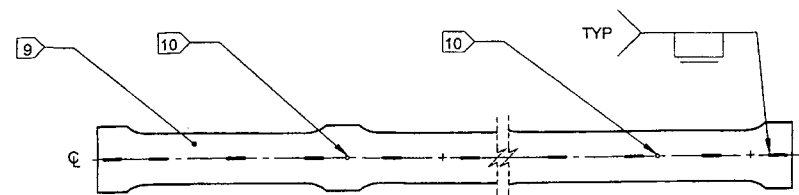
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. &
MFG. APPR.	DD	D4364	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	15.09.18	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
	X	D4364-041	FWD WEARPLATE ASSY
1	1	D4364-1	PLATE
2	1	D4365-041	BAR WELDMENT

△ C



D4364-041 FWD WEARPLATE ASSY △ C



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-041" PER QSI 044 6.1
- 7) WEIGHT: 4.03 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES THRU D4365-041 BAR WELDMENT FROM D4364-1 WEARPLATE AFTER WELDING
- 11) FORM TO MATCH PROFILE OF D4364-1 AT TIME OF WELDING

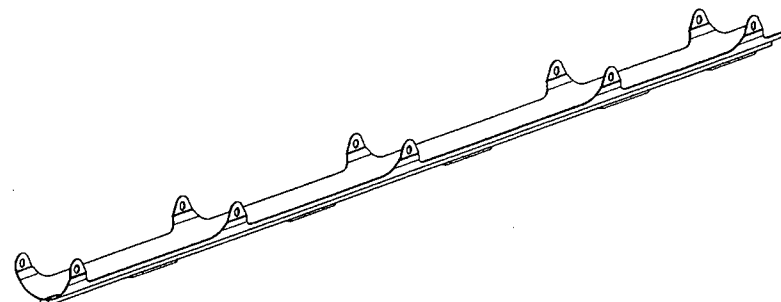
C	D4365-041 WAS D4365-1, D4365-043 WAS D4365-3, REMOVE 2659 HARDCOAT WELD (MOVED TO D4365), UPDATE TOLERANCES (SH 3&4), REMOVE VIEWS A-A, B-B (SH 2)	DB	16.01.21
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), CHANGE NOTE 10 (SH 2)	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.21	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-06-16
ECN 16-594

APPROVED

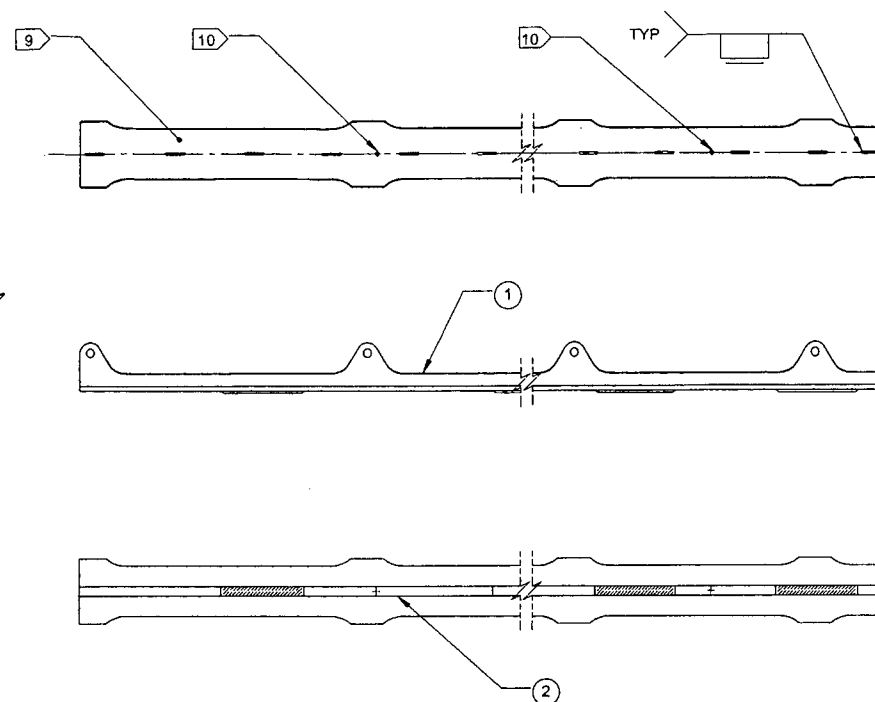
ITEM	QTY -043	P/N	DESCRIPTION
	X	D4364-043	WEARPLATE ASSY
1	1	D4364-3	PLATE
2	1	D4365-043	BAR WELDMENT

△ C



D4364-043 AFT WEARPLATE ASSY

△ C



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-043" PER QSI 044 6.1
- 7) WEIGHT: 5.88 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES THRU D4365-043 BAR WELDMENT FROM D4364-3 WEARPLATE AFTER WELDING

RELEASED
2016-06-16

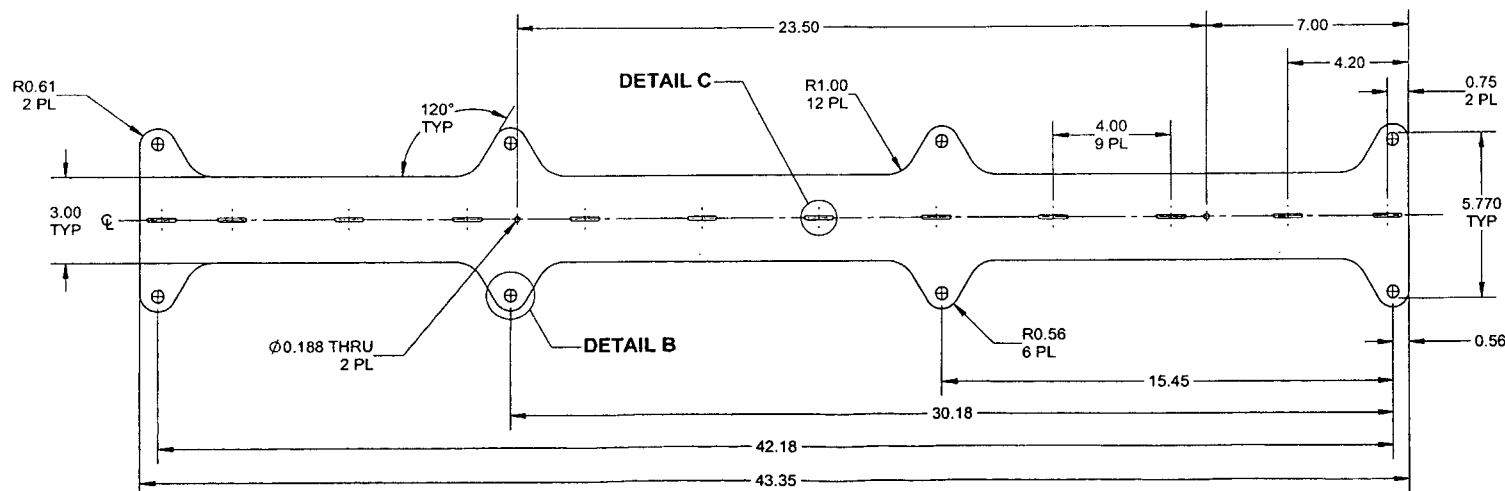
APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.21	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D4364-1 PLATE
(MAKE FROM D4364-1F)



D4364-1F PLATE
(FLAT PATTERN)



NOTES:

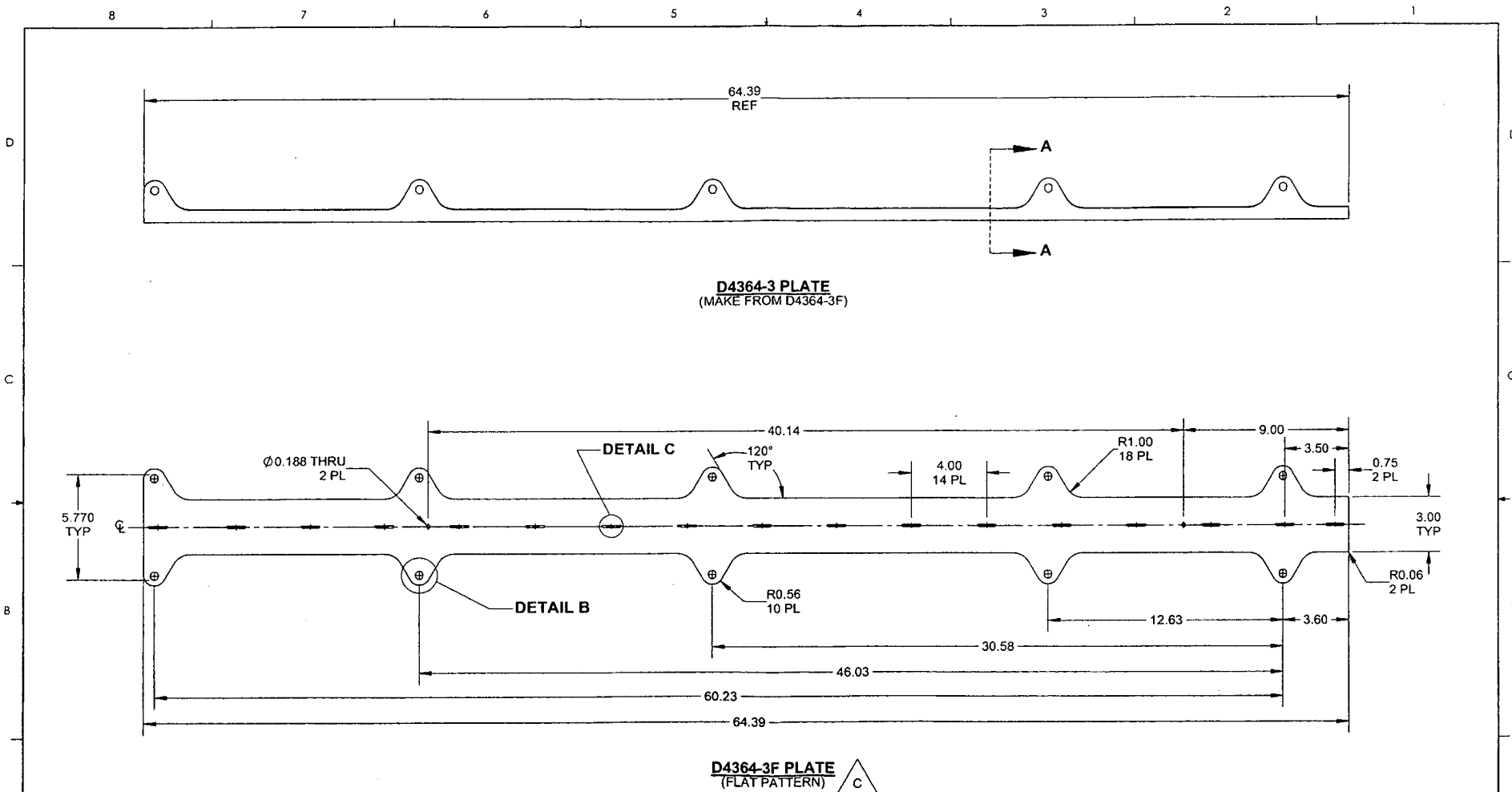
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.12 lbs

RELEASED
2016-06-16

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.21	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

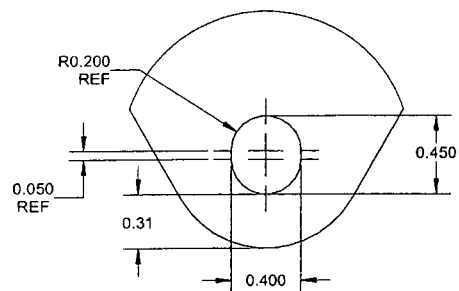


- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.10 lbs

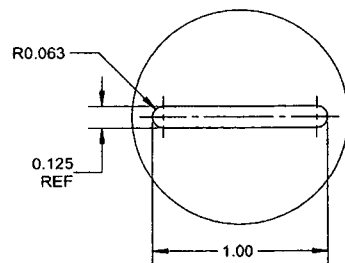
RELEASED
2016-06-16

APPROVED

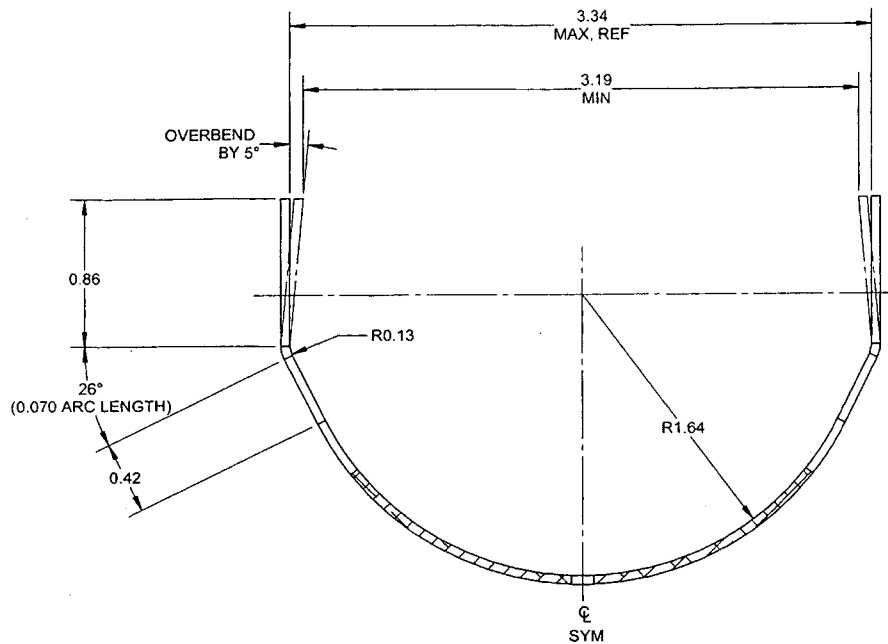
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.21	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



DETAIL B



DETAIL C



SECTION A-A

RELEASED
2016-06-16

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4364	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.21	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	